

Date: Tuesday, 8/28/2007 3:22:54 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 34310	
Estimate Number : 10348	
P.O. Number : <u>N/A</u>	Part Number : D28581
This Issue : 8/28/2007 S.O. No. : <u>NA</u>	Drawing Number : D2858 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NA</u> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 31698	Material : <u>NA</u>
Written By : <u>[Signature]</u>	Due Date : 9/30/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>37</u> Um: Each
Comment : Est C 08.06.22 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s)
Material: 1.50" X 1.25"
6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
(M6061T6B15001250)
Batch M104182

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks 6.02"
Note: 1 Blank Makes 3 Parts

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine per folio D2858-

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 21/06/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 3:22:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 34310

Part Number: D28581

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/10/22 (39)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Tumble
2-Deburr any rough edges after tumbling

N/A 07-10-23

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A 07-10-23

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.3

M-L 07/10/25

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M105068 07/10/25

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MS 07-10-25 x39

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ~~834310~~ ST51

07/10/26 18 (39x)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/26

Job Completion



U 07-10-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

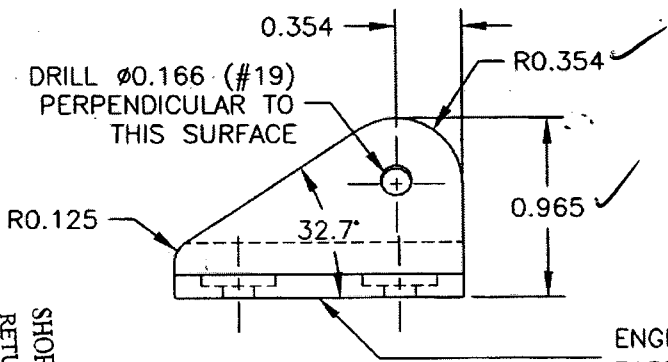
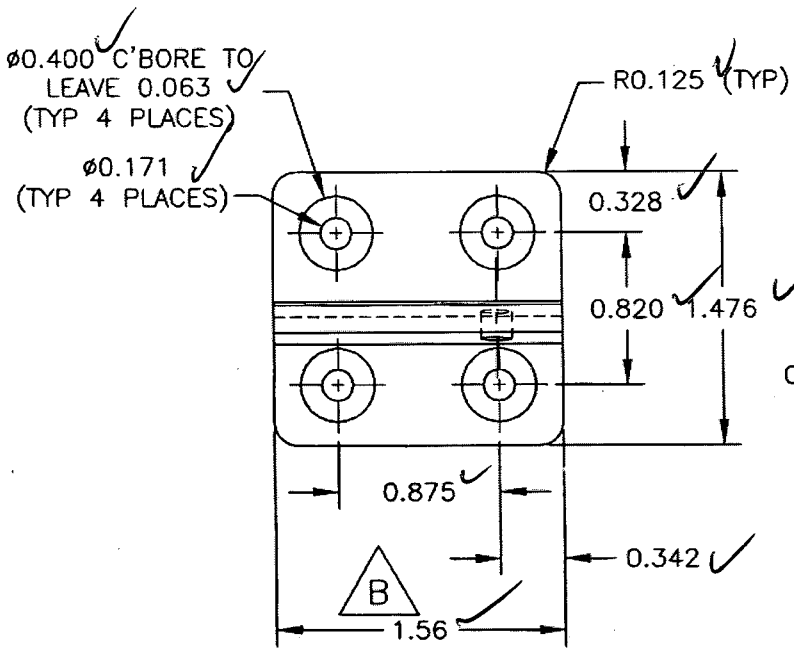
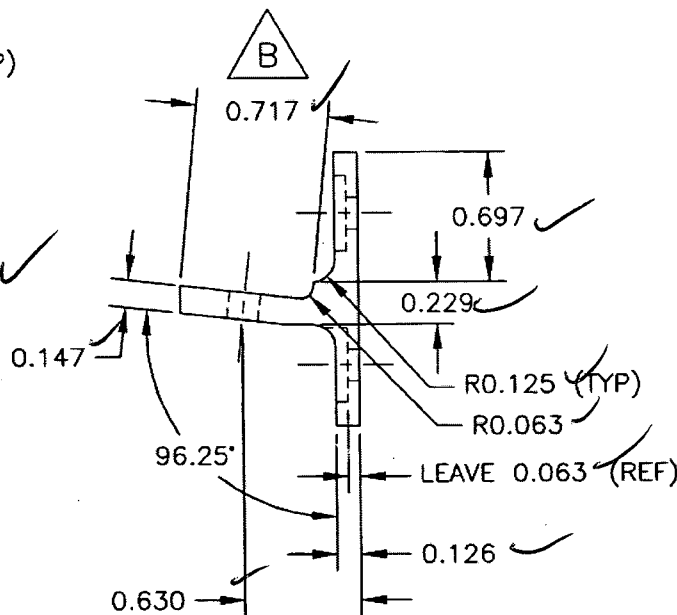
NOTE: Date & initial all entries

DART

ISSUED
COPY

RELEASED
99.07.09 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
VE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	KE	D2858
DATE	TITLE	REV. B
99.02.28	HINGE BRACKET	SHEET 1 OF 1
A	98.12.14	NEW ISSUE
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright 1998 by DART AEROSPACE LTD

WORK ORDER
NO. 34310

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

PART AEROSPACE LTD		Work Order:
Description: <u>Hinge Bracket</u>	Part Number: <u>D 2858-1</u>	
Inspection Dwg:	Rev: <u>B</u>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>Ø.400</u>	<u>399</u>	<u>399</u>	<u>/</u>			
<u>Ø.171</u>		<u>Ø.171</u>	<u>/</u>			
<u>R.125</u>		<u>R.125</u>	<u>/</u>			
<u>.328</u>	<u>±.010</u>	<u>.332</u>	<u>/</u>			
<u>.820</u>	<u>±.010</u>	<u>.820</u>	<u>/</u>			
<u>1.476</u>	<u>±.010</u>	<u>1.485</u>	<u>/</u>			
<u>.875</u>	<u>±.010</u>	<u>.876</u>	<u>/</u>			
<u>.342</u>	<u>±.010</u>	<u>.345</u>	<u>/</u>			
<u>1.56</u>	<u>±.030</u>	<u>1.566</u>	<u>/</u>			
<u>.147</u>		<u>.147</u>	<u>/</u>			
<u>.717</u>		<u>.715</u>	<u>/</u>			
<u>.697</u>		<u>.697</u>	<u>/</u>			
<u>.229</u>		<u>.235</u>	<u>/</u>			
<u>R.125</u>		<u>R.125</u>	<u>R.125</u>			
<u>R.063</u>		<u>R.063</u>	<u>R.063</u>			
<u>.063</u>		<u>.063</u>	<u>/</u>			
<u>.126</u>		<u>.126</u>	<u>/</u>			
<u>.630</u>		<u>.631</u>	<u>/</u>			
<u>There's more !!</u>						

Measured by: <u>SA</u> Date: <u>07.10.22</u>	Audited by: <u>J.S.</u> Date: <u>07/10/22</u>	Prototype Approval: Date:
Rev: <u>1</u> Date: <u>07.10.22</u> Change: <u>New Issue</u>	Revised by: <u>KJ/RF</u> Approved:	

[Handwritten signature]

